Date: User: Job Number This Issue Prsht Rev. First Issue Previous Run Written By

Tuesday, 11/6/2007 1:25:47 PM

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

: 35565 : 12723

Estimate Number

P.O. Number

: 11/6/2007

: NC

: //

: 32742

Type

S.O. No. :

: SMALL /MED FAB

Material **Due Date**

Drawing Name

Part Number

Drawing Number

Project Number

Drawing Revision

: 11/16/2007

: GASKET

: D353613

: N/A

: A

- D3536 REV A

Qty:

30 Um:

Each

Checked & Approved By

Comment

: Est Rev!A

New Issue 07-02-14 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description: NEOPRENE SHEET 0.063

1.0

MNEO60S063

33.8598

Comment: Qty.: 0.8682 sf(s)/Unit

Total: 26.0474 sf(s)

NEOPRENE SHEET 0.063

Batch: MIOS (13

2.0

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev: Prog Rev:_

07-11-12 B

2-Deburr if necessary

3.0

07-11-12



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

SECOND CHECK



Comment: SECOND CHECK

PACKAGING 1 5.0

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

E-PAIShING Location:

Dart Ae	rospace	Ltd		3					646
W/O:			W	ORK ORDER CHANGES					
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		•						ii.	
								4	
Part No	:	PAR #:	Fault Cate	gory: N				Date: _ Date:	
NCR:		· · · · · · · · · · · · · · · · · · ·	WORK ORD	ER NON-CONFORMANO	E (NCR	(1)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B Action Description Chief Eng	Sign &	Verific Section		Approval Chief Eng	Approval QC Inspector
9				0-					
			100					2.	
								:	

NOTE: Date & initial all entries

Date:

Tuesday, 11/6/2007 1:25:47 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 35565

Part Number: D353613

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



07.11.15/18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



a Hillily

Dart Ae	rospac	e Ltd								(#d)
W/O:			W	ORK ORDER CH	IANGES					
DATE	STEP	PF	ROCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					-					
	÷		3 161							
Part No):	PAR #:	Fault Cate	gory:	NC					
	-	,							_ Date: _	
NCR:			WORK ORD	ER NON-CONFO	DRMANCE	E (NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descri	Section B ption	Sign & Date	Verifica Section		Approval Chief Eng	Approval QC Inspector
						1				

NCR:		W	ORK ORD	ER NON-CONFORMANCE	(NCR)			ā
		Description of NC		Corrective Action Section B	2=	Verification	Anneval	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approva QC Inspecto
						·		
. 1							÷	
	;							•
						F		
		9						
				4				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35565
Description: Gasket	Part Number:	D3536-13
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.90	+/-0.030	33.90	-7			
29.40	+/-0.030	29,40	Ú			
27.40	+/-0.030	27.40	V			
23.90	+/-0.030	33.90				-
18.98	+/-0.030	18-98				
14.07	+/-0.030	14.07	/			
9.15	+/-0.030	9.15	/			
5.65	+/-0.030	5.65	/			
3.90	+/-0.030	3,40	/			
8.00	+/-0.030	8-05	V			·
14.00	+/-0.030	14.00	1			
20.00	+/-0.030	30.00	1			
1.89	+/-0.030	1.89				93
0.30	+/-0.030	36	/			
0.30	+/-0.030	-30	V			
Ø0.19	+0.005/-0.001	,19				
		,				
÷ ·						

Measured by: | Audited by: | Prototype Approval: N/A

Date: | Date: | Date: N/A

Rev	Date	Change	Revised by	Approved
Α	07.06.13	New Issue	KJ/JLM 🕉	+ B

5

 \mathcal{Z}

D3536

SHEET 1 OF 6

SCALE 1:10

DRAWING NO

DART

AEROSPACE PORT HADLOCK,

USA

NC.

06. ME

5 .25

GASKET

06.10.25

NEW

ISSUE

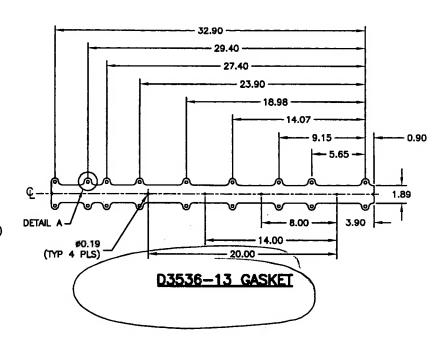
26.65	
23.15	
21.15	
17.65	
13.40	
9.15	0.90
5.65	Į.
	1
	\L
Ç	1.89
DETAIL A	- '
(TYP 3 PLS) 14.00	-

D3536-11 GASKET

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE SHOP COPY ENGINEERING RETURN TO

- 1)" MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT &
 4) TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



1 <u>"</u>
Copyright © 2006 by DART AEROSPACE USA, INC. PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.
Copyright © 2006 by DART AEROSPACE USA, INC. INATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR AND OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.
Copyright © 2006 by DART AEROSPACE USA, INC. INTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AERO TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION P
\$ 5
25 PG 20
P EEE
\$ ₹
RES (S
일 문 중
5 × 5 × 5 × 5 × 5 × 5 × 5 × 5 × 5 × 5
A N
SSP BE
ÇE USE
Ş _Ğ
NC. AN
I 🛈

PURPOSE

엻

COPIED

봀

DOCUMENT

ᄶ



CHECKED

B

APPROVED

D3536

돼

유 SCALE 1:10

DRAWING NO.

DART

AEROSPACE PORT HADLOCK,

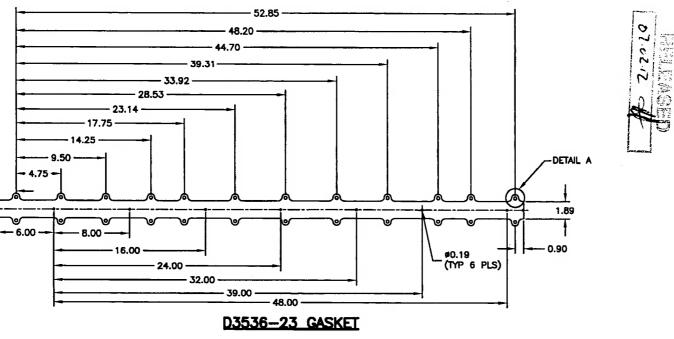
NC.

B

DATE

06.10.25

GASKET



UNCONTROLLED COPY SUBJECT TO AMENDMENT SHOP COPY ENGINEERING RETURN TO WITHOUT NOTICE

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

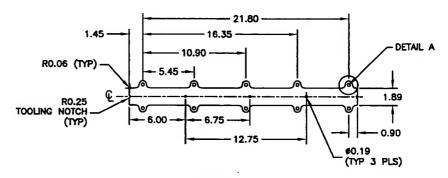
2.00

2) FINISH: NONE 3) PART IS SYMM

PART IS SYMMETRICAL ABOUT ©
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-25 GASKET

DOCUMENT ᇬ Copyright © 2006 by DART AEROSPACE USA, IN PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART. INC.
Of to be used for any of aerospace usa, inc. PURPOSE 욹 COPIED

拭S

DATE

CHECKED

APPROVED

 \mathcal{Z}

D3536 DRAWING NO.

SHEET

4 OF 6 SCALE 1:10

B

(D^図

DART

AEROSPACE PORT HADLOCK,

USA,

NO.

06.10.25

GASKET

H

07,02.12

DETAIL A

24.50 21.00 2.00 ---6.00 1.89 6.00 ≠0.19 (TYP 3 PLS)

D3536-33 GASKET

22.50 19.00 2.00 -6.00 Ç. 1.89 DETAIL A ≠0.19 (TYP 3 PLS)

D3536-31 GASKET

SHOP COPY
SHOP COPY
RETURN TO
RETURN TO
RETURN TO
AMENDMENT

BLACK NEOPRENE SHEET, 1/16 THICK, 60
DUROMETER (REF DART SPEC. M-NEO60-S WITHOUT NOTICE

- DUROMETER (REF DART SPEC. M-NEO60-S.063)
- FINISH: NONE
- 2) 3)
- PART IS SYMMETRICAL ABOUT & TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

D3536-35 GASKET

23.25 19.75 17.75 14.25 9.50
1.89 @
6.00 - 6.75 - 00.19 (TYP 2 PLS) DETAIL A

 $\overline{\mathbf{o}}$ Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. PURPOSE 욹 COPIED

봀

DOCUMENT

7.02.12

ζ Copyright © 2006 by DART AEROSPACE USA, IN PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART. INC.
OT TO BE USED FOR ANY
OT AEROSPACE USA, INC.

PURPOSE

유

COPIED

붚

DOCUMENT

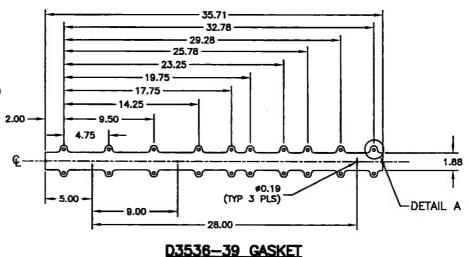
30.75 27.25 22.50 2.00 4.75 1.89 E 6.00 8.00 21.00 D3536-37 GASKET SUBJECT TO AMENDICACK NEOPRENE SHEET, 1/16 THICK, 60

DURCOMETER (REF DART SPEC. M-NEOBO-S.063)

TNICH: NONE

OSI 018 UNLESS 2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

7) SEE PAGE 6 FOR DETAILS AND SECTION



DETAIL A

#0.19 (TYP 4 PLS)

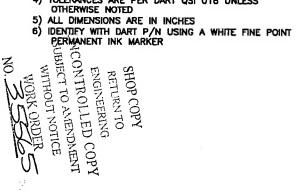
CB	CB	DAR	PORT HADLOCK, WA	USA, INC.
CHECKED	APPROVED	DRAWING NO.		REV. A
₹	#	D3536		SHEET 5 OF 6
DATE		TILL		SCALE
06.10.25		GASKET		1:10

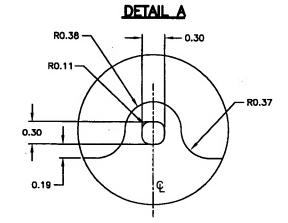
CB	C B	DART AEROSPACE USA, INC.	, INC.
CHECKED	APPROVED	DRAWING NO.	REV.
*	#	D3536	SHEET 5 OF
DATE		TIME	ros Vos

27.98 25.08 18.50 15.00 2.00 -6.93 -3.43 1.88 4.00 **Ø**0.19 (TYP 2 PLS) DETAIL A

D3536-41 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE 3) PART IS SYMM
- PART IS SYMMETRICAL ABOUT & TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





CB	CB	DAKI	PORT HADLOCK, WA	ACA,	<u>N</u> C.
CHECKED	W DEMONDED	DRAWING NO.			REV. A
TA TA	#	D3536		SHS	SHEET 6 OF 6
DATE		אוורב			SCALE
06.10.25		GASKET			1:10